

Date: Tuesday, 15/07/2008 3:38:36 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VALVE SUPPORT
Job Number	: 40468		
Estimate Number	: 11910		
P.O. Number	:	Part Number	: D2002001
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D2002-001
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 15/07/2008 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	:	Material	:
Written By	: <u>08.07.15.</u>	Due Date	: 21/07/2008 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est. C 99.05.26 Re-format, Added inserts and alodine D M		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.2588 sf(s)/Unit Total : 1.5530 sf(s)

2024-T3 .063 sheet

Material: 2024-T3, 0.063" Thick

Batch 108415

HB 8-7-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2002-001

Dwg Rev: C

Prog Rev: C

HB 8-7-17

2-Deburr if necessary

HB 8-7-17

(9)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-7-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/07/17 (89)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D2002-001

SPB 08/07/17 23

(9)

6.1 inspect QC #5

S 08/07/03 (79)

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Job Number: 40468

Part Number: D2002001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL/AM

08/07/23

7.0

FE032

Insert



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

6 FE-032 Inserts *M108634*

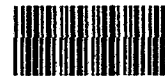
SB 08/07/24

(9)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2002-001

Install paint screws

08/07/24

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/07/24 (+S)

10.0

POWDER COATING

POWDER COATING



M102316



(9X)

Comment: Powder Coat Black Crinkle (Ref 4.3.5.3) as per QSI 0054.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*2:20
320°F
2:50*

M-L 08/07/24

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/24 (9)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/07/24 (9)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



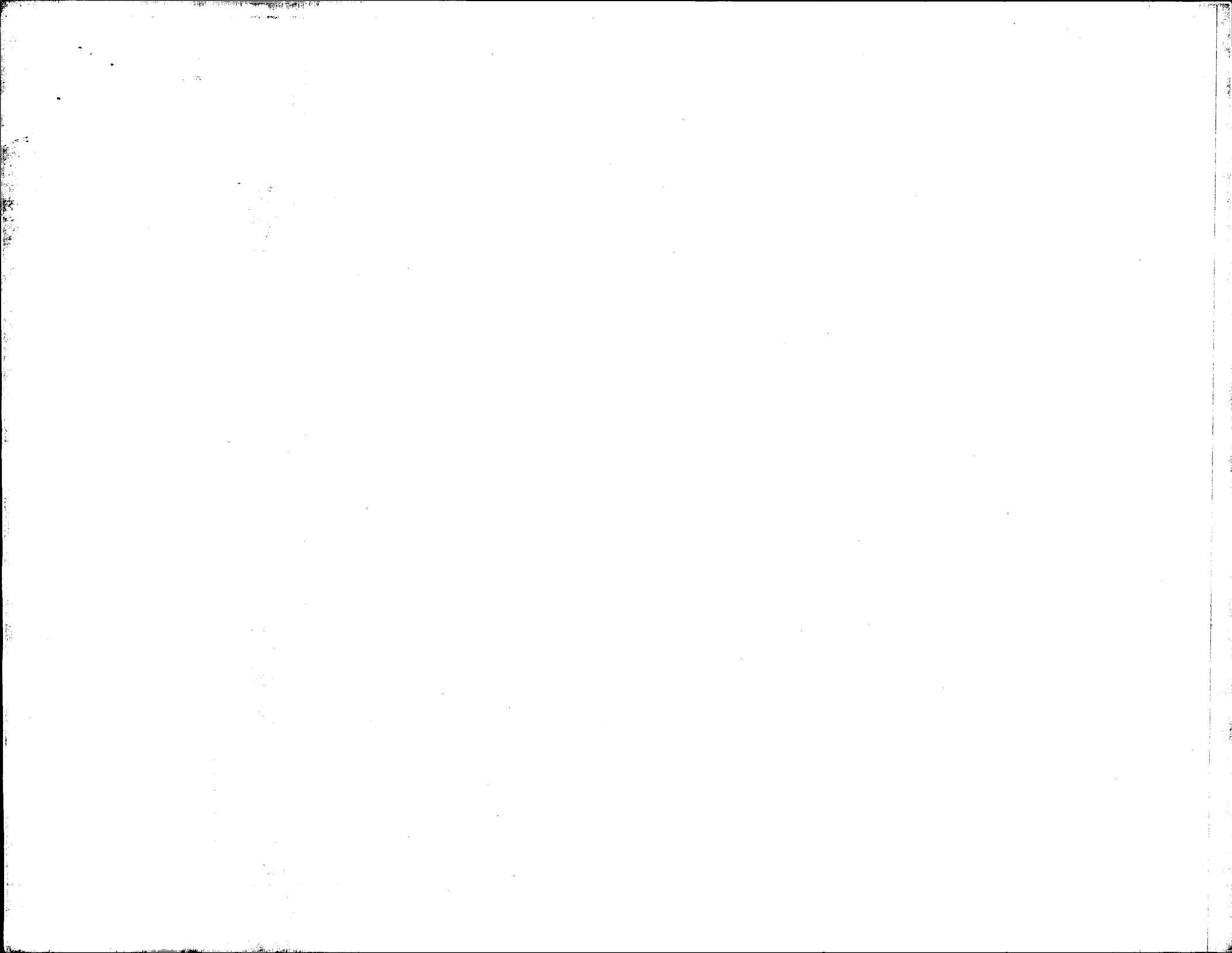
08/07/30 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-29



DART AEROSPACE LTD		Work Order: 40468
Description: Valve Support		Part Number: D2002-001
Inspection Dwg: D2002-001 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

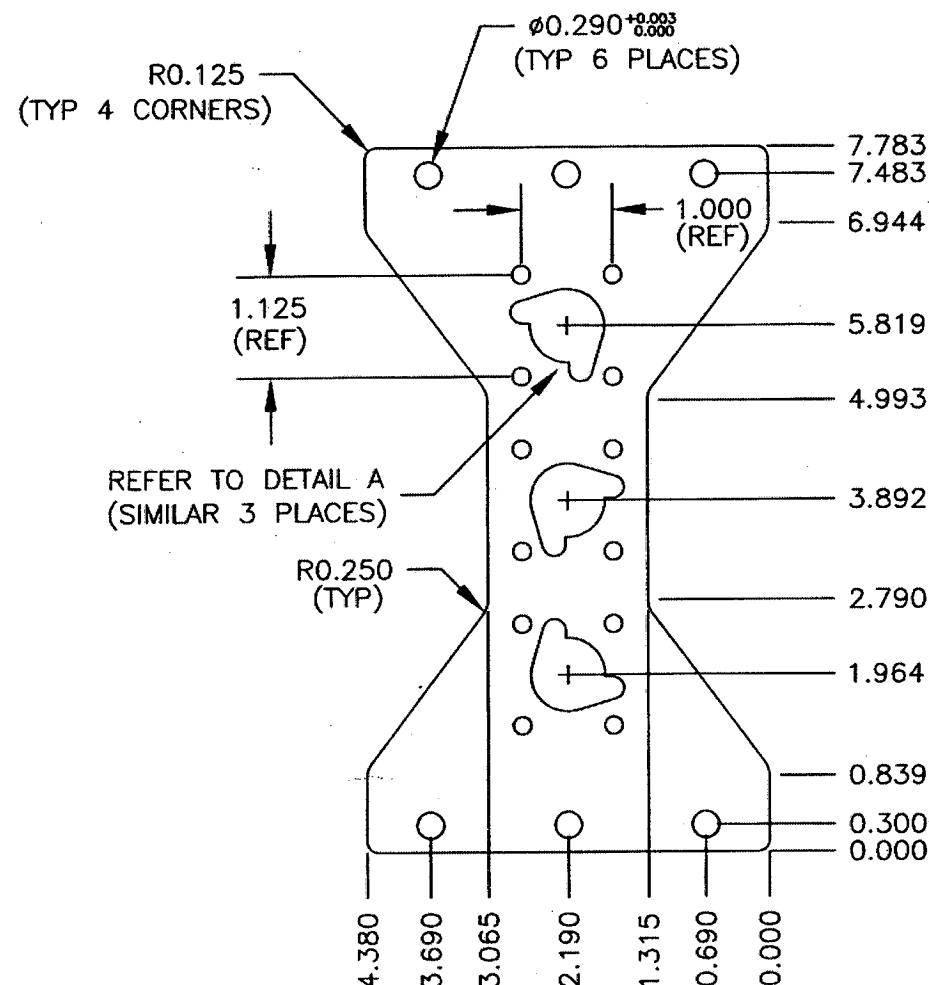
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	.125	x			
Ø0.290	+0.005/-0.000	.294	x			
1.125	+/-0.010	1.122	x			
R0.250	+/-0.010	.250	x			
4.380	+/-0.010	4.386	x			
3.690	+/-0.010	3.692	x			
2.190	+/-0.010	2.192	x			
0.690	+/-0.010	.691	x			
0.300	+/-0.010	.302	x			
1.964	+/-0.010	1.965	x			
3.892	+/-0.010	3.890	x			
5.819	+/-0.010	5.819	x			
7.483	+/-0.010	7.483	x			
7.783	+/-0.010	7.782	x			
1.000	+/-0.010	.997	x			
Detail A						
1.125	+/-0.010	1.125	x			
Ø0.812	+0.005/-0.000	.814	x			
Ø0.256	+0.005/-0.000	.256	x			
Ø0.194	+0.005/-0.000	.196	x			

Measured by: KB	Audited by: S	Prototype Approval:	N/A
Date: 8-7-17	Date: 08/07/17	Date:	N/A

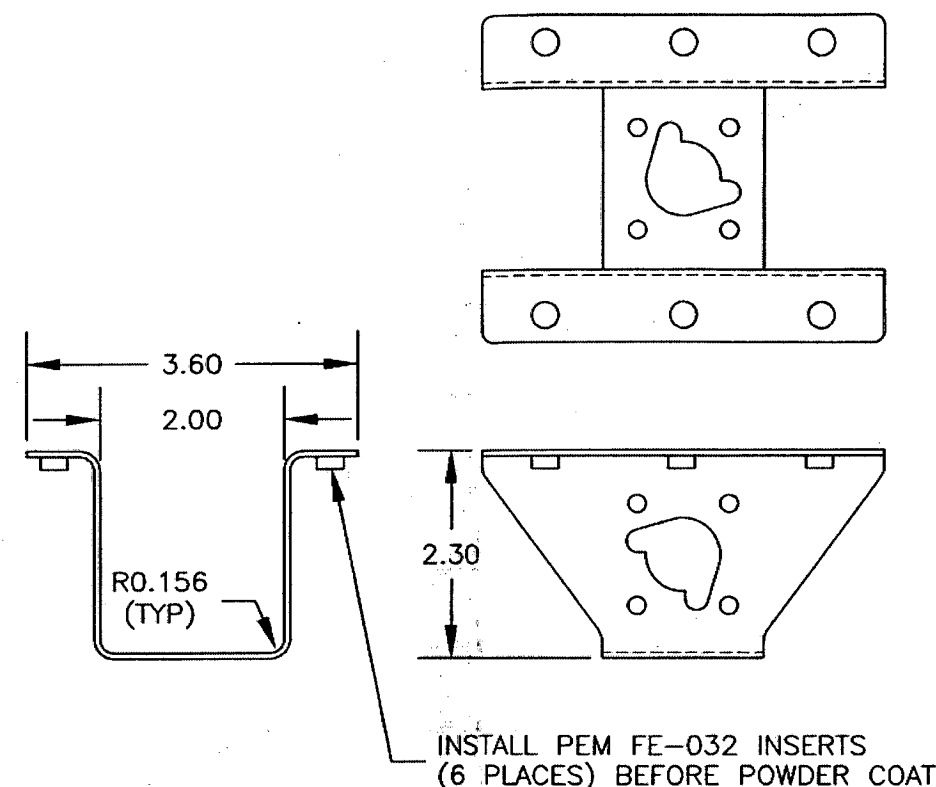
Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	[Signature]



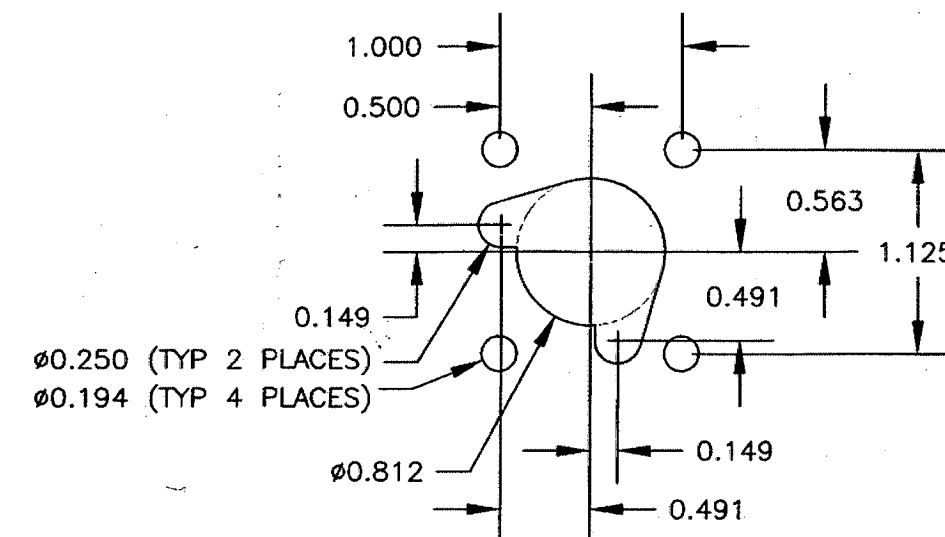
RELEASED
98.10.26 DS



D2002-001 FLAT PATTERN



D2002-001 BENDING DETAIL



DETAIL A
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40408

GENERAL NOTES

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063 THICK
MINIMUM BEND RADIUS: 0.156
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK CRINKLE (REF 4.3.5.3) PER DART QSI 005 4.3
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C	98.10.19	REDRAWN, UPDATED DWG NOTES UPDATED DETAIL A
B	95.10.27	ADDED FLAT PATTERN
A	94.11.18	NEW ISSUE
DESIGN BW	DRAWN BY 	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2002-001
DATE 98.10.19		TITLE VALVE SUPPORT
		REV. C SHEET 1 OF 1 SCALE 1:2